

Date: Tuesday, 6/27/2006 8:38:32 AM
 User: Linda Lacelle

B 27394

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT ASSEMBLY
 Job Number : 27651
 Estimate Number : 11248
 P.O. Number : *N/A*
 This Issue : 6/27/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : 6/19/2006 Type : LARGE FAB ASSY
 Previous Run : 27416
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *[Signature]*
 Comment : Est A 05.05.18 New Issue KJ/JLM

Part Number : D3438042
 Drawing Number : D3438 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 7/10/2006 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D267334 End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part No. Description Batch
 2 D2673-34 End Cap

B 25396

PE 06.06.27 2

2.0 D2561 Lug Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part No. Description Batch
 2 D2561 Lug Plate

(B 27417 = 2)

PE 06.06.27 2

3.0 D2564 Mounting Angle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part No. Description Batch
 2 D2564 Mounting Angle

B 25970 = 2 B 27148 = 2

PE 06.06.27 2

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 79.63° at 34° as per Dwg D3438

2-Deburr ends

PE 06.06.27 2
PE 06.06.27 2

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT ASSEMBLY

Job Number: 27651

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Inspect for foreign object per QSI 024

4-Weld as per Dwg D3438 using DT8343

~~5-Weld last end cap as per drawing.~~

5-Grind

LE. 06.06.27 2

LE. 06.06.27 2

FF 06.06.28 2

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

QC9 -> PD 06.06.28 (2)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06.06.28 2

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

A.M 06-07-13 (2)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg 3438 and QSI 005 4.4

Mask off 0.5 each side of D2561 lugs

SC 06/07/13 (2)
DL

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/07/13 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: —

N/A

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.17

U 06.07.17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
060704	6.1	QC3 Inspect Alodine.		06-06-30	2	V	J	
	6.2	- check for foreign objects. weld. ins + end cap D2673-34 AS per QSI004 = grind flush.		06-06-30	2			
	6.3	QC5/9 Inspect work = weld = for foreign objects.		06-07-04	2			
060704	6.4	Alodine end cap AS NECESSARY AS per QSI005 4.1.	FF	06-06-28	2			
	A	make change AS shown						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:31:09 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP WELDMENT ASSEMBLY	
Job Number :	27651	Part Number :	D3438042	
Estimate Number :	11248	Drawing Number :	D3438 REV A	
P.O. Number :		Project Number :	N/A	
This Issue :	6/19/2006	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	A	
First Issue :	/ /	Type :	LARGE FAB ASSY	
Previous Run :	27416	Material :		
Written By :		Due Date :	7/10/2006	Qty: 2 Um: Each
Checked & Approved By :	<i>[Signature]</i> 06.06.19			
Comment :	Est A05.05.18 New Issue KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3438042	Step Weldment Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Step Weldment assembly
 Pick:
 1 D2244 Step Extrusion
 Batch: _____

2.0	D267334	End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

Qty	Part No.	Description	Batch
2	D2673-34	End Cap	_____

3.0	D2561	Lug Plate
-----	-------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

Qty	Part No.	Description	Batch
2	D2561	Lug Plate	_____

4.0	D2564	Mounting Angle
-----	-------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

Qty	Part No.	Description	Batch
2	D2564	Mounting Angle	_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Date: Monday, 6/19/2006 11:31:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT ASSEMBLY

Job Number: 27651

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 79.63" at 34° as per Dwg D3438

2-Deburr ends

3-Inspect for foreign object per QSI 024

4-Weld as per Dwg D3438 using DT8343

5-Grind

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg 3438 and QSI 005 4.4

Mask off 0.5 each side of D2561 lugs

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:31:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT ASSEMBLY

Job Number: 27651

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

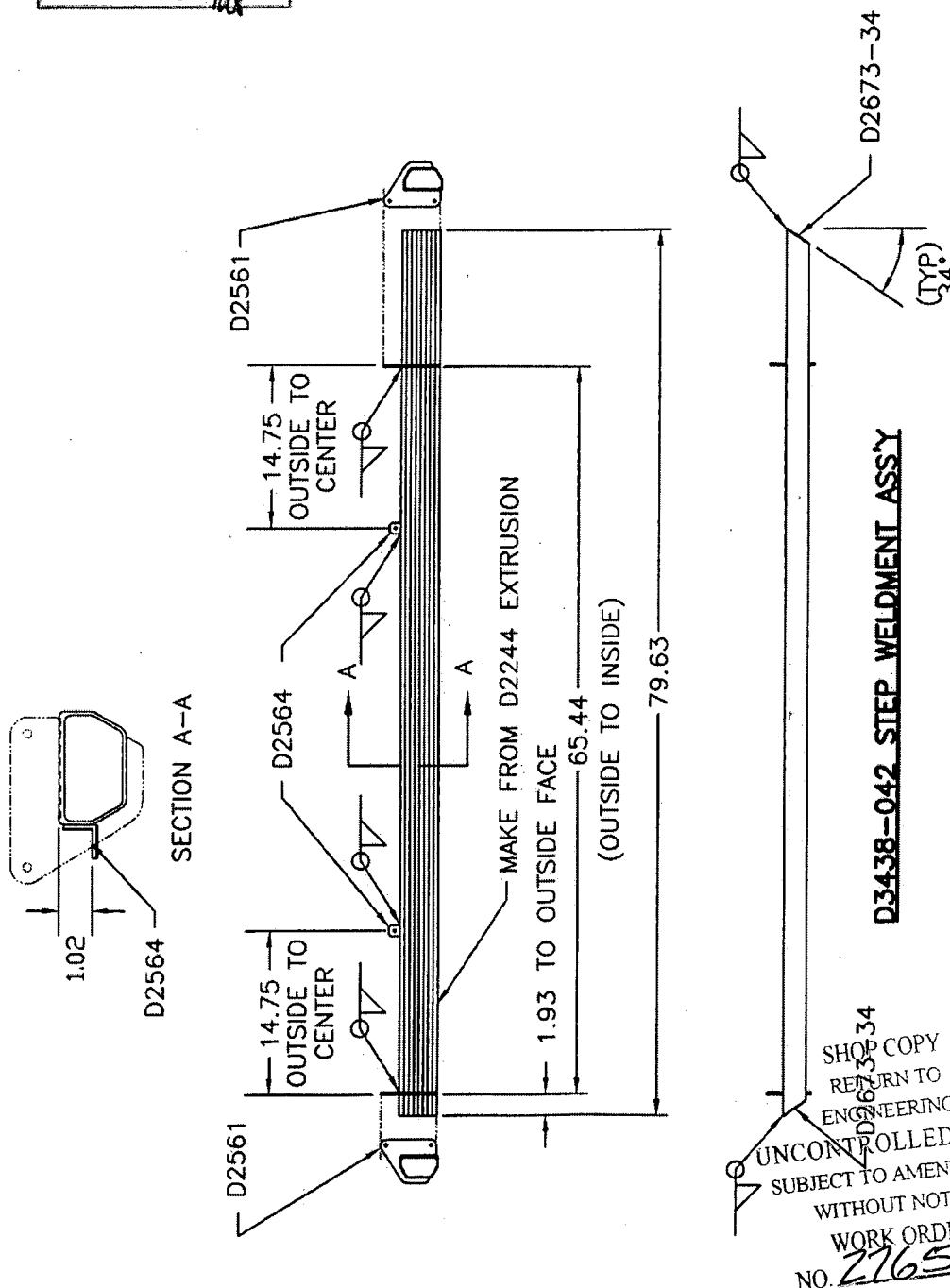
QA: N/C Closed: _____ Date: _____

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3438	REV. A SHEET 1 OF 1
DATE 05.05.09	TITLE STEP WELDMENT ASSEMBLY		SCALE 1:1
A	05.05.09	NEW ISSUE	

RELEASED

05.05.22



- NOTES:
- 1) WELD PER DART QSI 004
 - 2) TOLERANCES ARE PER DART QSI 018
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1 WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

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